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D4635-143
Job Sheet 203512



Part No: D4635-143

Job Qty: 1 pcs

Part Name: Aft Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/19

Job Tracking No:

Due Date: 1/20/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4635 REV.G SHEET 11 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL ver:DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	1/20/20	1/20/20	0.00	0.68	Small Fab - 1		DAS 58 JAN 14 2020 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
120	QC 5	1 pcs	1/20/20	1/20/20	0.00	0.00	QC 5 - 10		DAS 40 JAN 15 2020 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	1/20/20	1/20/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	1/20/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS
58 JAN 15 2020
9-8

DAS
21
9-8

JAN 16 2020

Part Op 110 - (Small Fab) Assemble as per Dwg D4635-143 Bond foam core to inside of panel 3M Scotch Weld 1300
 Descriptions: Batch: 5214697 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # 5159491 Expiry Date 03/27/2020 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch: m138961 24/05/2020
 120 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location:
 140 - QC21- Final Inspection - Work Order Release fg234

013889

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-3	Aft Ceiling Panel, LH	1 pcs (1 ea)	110-Small Fab - 1	513077
D4669-1	Bracket	1 pcs (1 ea)	110-Small Fab - 1	5136218
D4669-3	Bracket	1 pcs (1 ea)	110-Small Fab - 1	5117668
D4695-3	Channel	1 pcs (1 ea)	110-Small Fab - 1	5134899
D4732-1	Label	1 pcs (1 ea)	110-Small Fab - 1	5224077
D4732-13	Label	1 pcs (1 ea)	110-Small Fab - 1	5224380
D4732-37	Label	1 pcs (1 ea)	110-Small Fab - 1	5224674
D5022-3	Foam, Side Panel, Aft	1 pcs (1 ea)	110-Small Fab - 1	5123659

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	D4635-3	1	1	0
	D4669-1	1	8	0
	D4669-3	1	40	0
	D4695-3	1	1	0
	D4732-1	1	9	0
	D4732-13	1	12	0
	D4732-37	1	10	0
	D5022-3	1	2	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		MRB (QSI042)	
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY					
		Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	
Completed By _____		Lead hand / Supervisor _____					
QC / QA Coordinator _____							